

Date: Friday, 19/12/2008 10:42:41 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 44206		Part Number	: D2573		
Estimate Number	: 10533		Drawing Number	: D2573 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 19/12/2008		Drawing Revision	: E		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 10/01/2009		
Previous Run	: 43898		Qty:	8		
Written By			Um:	Each		
Checked & Approved By	<u>JUL 08.12.19</u>					
Comment	: Est: 1 As Per RevE 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>512991</u> <u>DJP 09/01/08</u> <u>8</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>44206</u> Double check by: <u>H.A.</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	<u>8</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 <u>J.F./DJP 09/01/08</u> <u>8</u>	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>J.F./DJP 09/01/08</u> <u>8</u>	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 19/12/2008 10:42:41 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number: 44206		Part Number: D2573
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		JL 09/01/15
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		a.m 09.01.19 (8)
7.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		m109896 (8)
START TIME: 2:45 OVEN TEMPERATURE: 320° FINISH TIME: 8:15		FL 09/01/20
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		a.m 09.01.20 (8)
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 434		8X (8)
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		9/1/26 (8)
Job Completion		 MF 09-01-24

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 4420P	
Description: Saddle, Aft Outboard				Part Number: D2573	
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.441	0.440	0.441	0.441		
B	1.745	1.755		1.748	1.749	1.749	1.749		
C	3.495	3.505		3.499	3.501	3.500	3.499		
D	1.745	1.755		1.748	1.749	1.749	1.750		
E	7.990	8.010		8.002	8.002	8.003	8.003		
F	0.490	0.510		0.4995	0.504	0.503	0.501		
G	0.257	0.262		0.259	0.258	0.258	0.258		
H	0.375	0.380		0.377	0.376	0.376	0.376		
I	0.490	0.510		0.498	0.501	0.502	0.501		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		0.568	0.571	0.566	0.569		
L	1.174	1.184		1.179	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.371	1.371	1.371		
N	2.495	2.505		2.500	2.502	2.502	2.502		
O	4.119	4.129		4.124	4.125	4.125	4.125		
P	0.115	0.135		0.125	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.251	0.251	0.251		
S	0.115	0.135		0.123	0.122	0.123	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.228	3.234	3.234	3.234		
V	0.230	0.250		0.230	0.236	0.236	0.242		
W	0.115	0.135		0.128	0.129	0.130	0.135		
X	0.308	0.313		0.312	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.365	0.352	0.360	0.362		
AA	0.470	0.530		0.500	R.500	R.500	R.500		
AB	0.615	0.635		0.630	0.635	0.624	0.623		
AC	0.053	0.073		0.063	R.063	R.063	R.063		
AD	0.240	0.260		0.243	0.240	0.245	0.247		
AE	1.500	1.520		1.5155	1.516	1.518	1.513		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.255	0.254	0.254	0.254		
AH	0.240	0.260		0.244	0.245	0.245	0.250		
AI	2.000	2.020		2.006	2.006	2.008	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	DTP/J.F.	Audited by:	J.L.
Date:	09/01/13	Date:	09/01/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JLM

DART AEROSPACE LTD				Work Order:	44204
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		0.441	0.441	0.441	0.441		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.749	1.749		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		0.500	0.493	0.493	0.494		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.499	0.499	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.565	0.564	0.564	0.5		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.125	4.124	4.124		
P	0.115	0.135		0.126	0.126	0.126	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.251	0.251	0.251		
S	0.115	0.135		0.127	0.124	0.125	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.228	3.228	3.228		
V	0.230	0.250		0.236	0.236	0.236	0.236		
W	0.115	0.135		0.135	0.130	0.132	0.132		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.7600	.7600	.7600	.7600		
Z	0.352	0.372		0.360	0.360	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.616	0.617	0.6195	0.617		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.255	0.245	0.255	0.248		
AE	1.500	1.520		1.5125	1.5165	1.5155	1.5175		
AF	0.115	0.135		0.132	0.130	0.130	0.130		
AG	0.240	0.280		0.280	0.280	0.280	0.280		
AH	0.240	0.260		0.246	0.245	0.244	0.243		
AI	2.000	2.020		2.000	2.003	2.0045	2.005		
AJ	0.023	0.043		0.033	0.033	.033	0.033		
Accept/Reject									

Measured by:	DTI	Audited by:	JL
Date:	09/01/13	Date:	09/01/15

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